

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Work Order ID 147347

Wednesday, December 07, 2016 11:33:12 A

147347

Page 2

Item ID: D3782-045 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Back Leg Assembly
Start Date: 6/3/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 6/8/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>CSA</i>	0.00			<i>DAS</i> <i>30</i> <i>9-89</i>	<i>2</i>			<i>DEC 12 2016</i>
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00			<i>DAS</i> <i>21</i> <i>9-89</i>				
140									<i>DEC 13 2016</i>
QC	Memo	0.03							
Quality Control									

VS 16/12/13

DAS
21
9-89

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Picklist Print

Wednesday, December 07, 2016 11:33:17 AM

Page 1

Work Order ID: 147347

147347

Parent Item: D3782-045

D3782-045

Parent Item Name: Back Leg Assembly

Start Date: 6/3/2016

Required Date: 6/8/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-06-17 rev.A as per dwg DD verified by:EC IPP Rev:C
10.02.22 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued DAS 6 9-89	Date Issued	Status
D3772-1 *D3772-1* Back Leg		Manufactured	No			110	Each	5.0000	1	2			
					<u>Location</u>			<u>Loc Qty</u>					
					ST255			5					
					143775			5					
D3787-1 *D3787-1* Foot		Manufactured	No			110	Each	16.0000	1	2			
					<u>Location</u>			<u>Loc Qty</u>					
					ST253			16					
					143829			6					
					150079			10					
D3764-1 *D3764-1* Back Leg Fitting		Manufactured	No			110	Each	8.0000	1	2			
					<u>Location</u>			<u>Loc Qty</u>					
					ST251			8					
					142124			2					
					143776			6					
D3773-041 *D3773-041* Headrest Assembly		Manufactured	No			110	Each	2.0000	1	2			
					<u>Location</u>			<u>Loc Qty</u>					
					ST252			2					
					145955			2					

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Parent Item Name: Back Leg Assembly

Start Date: 6/3/2016

Required Date: 6/8/2016

Start Qty: 2.00

Required Qty: 2.00

D3786-1

Manufactured No

110 Each

7.0000

1 2

D3786-1

Sleeve

**

Location

Loc Qty

Loc Code

ST253

7

143777

7

AN45-15A

Purchased No

110 Each

9.0000

1 2

AN45-15A

EYE BOLT

**

Location

Loc Qty

Loc Code

ST339

9

m134587

2

m135544

5

m135998

2

AN5-15A

Purchased No

110 Each

46.0000

1 2

AN5-15A

Bolt

**

Location

Loc Qty

Loc Code

GA

7

m132930

7

ST337

39

m135390

39

DAS
6
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QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
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Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																			
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OTHER :																					

Picklist Print

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Page 3

Work Order ID: 147347

147347

Parent Item: D3782-045

D3782-045

Parent Item Name: Back Leg Assembly

Start Date: 6/3/2016

Required Date: 6/8/2016

Start Qty: 2.00

Required Qty: 2.00

AN5-17A

Purchased

No

110

Each

150.0000

1

2

AN5-17A

Bolt

Location

Loc Qty

Loc Code

GA

21

117872

21

over003

80

m136047

80

ST337

49

m135297

49

AN4-15A

Purchased

No

110

Each

905.0000

2

4

AN4-15A

Bolt

Location

Loc Qty

Loc Code

GA

10

120449

10

over003

645

m135859

645

ST343

250

m135859

250

DAS
6
9-89
DEC 12 2016

DAS
6
9-89
DEC 12 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER :																					

Picklist Print

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Page 4

Work Order ID: 147347

147347

Parent Item: D3782-045

D3782-045

Parent Item Name: Back Leg Assembly

Start Date: 6/3/2016

Required Date: 6/8/2016

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

110

Each

2,690.000

2

4

MS21042L 4

Nut

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

18

m133363

18

GA

196

m135058

196

OVER007

2000

m135979

500

m136182

500

m136295

1000

ST303

476

153851

57

m135864

419

DEC 12 2016

MS21042L5

Purchased

No

110

Each

431.0000

3

6

MS21042L 5

Nut

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

25

m127813

25

OVER007

300

m136047

200

m136295

100

ST303

106

m135297

2

m135544

34

m135774

70

DEC 12 2016

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Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

Picklist Print

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Page 5

Work Order ID: 147347

147347

Parent Item: D3782-045

D3782-045

Parent Item Name: Back Leg Assembly

Start Date: 6/3/2016

Required Date: 6/8/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0463J

Purchased

No

110

Each

3,325.000

4

8

NAS1149D0463.J

Washer

NAS
6
9

Location

Loc Qty

Loc Code

GA	80	
M134508	13	
M135056	67	
ST260a	1200	
M136192	600	
M136263	600	
ST263	2045	
M135671	3	
M135948	442	
M136044	1600	

DEC 12 2016

NAS1149D0563J

Purchased

No

110

Each

1,442.000

5

10

NAS1149D0563.J

Washer

NAS
6
9-89

Location

Loc Qty

Loc Code

GA	61	
m133769	61	
ST263	1381	
m135470	3	
m135774	678	
m136295	700	

DEC 12 2016

10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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		☐ OTHER : _____																																	